

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81677***81677***

Page 2

March-16-12 1:58:02 PM

Item ID: D4108-049 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Litter Door Fitting Assembly
Start Date: 16/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 22/03/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/11/59 J
MCS 12-11-02

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NOTE: Date & initial all entries

Picklist Print

March-16-12 1:58:05 PM

Page 1

Work Order ID: 81677

81677

Parent Item: D4108-049

D4108-049

Parent Item Name: Litter Door Fitting Assembly

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD IPP
Rev:B 10.12.03 as per dwg rev.B DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3622-1

Manufactured

No

110

Each

50.0000

1

6

D3622-1

Ball Stud

**

FF 12-11-01

Location

ST058

87640

80533

78837

80405

Loc Qty

50

30

20

Loc Code

2

4

NAS1149C0532R

Purchased

No

110

Each

485.0000

2

12

NAS1149C0532R

WASHER

**

FF 12-11-01

Location

ST297

122441

116373

116513

118384

119736

Loc Qty

485

1

53

31

400

Loc Code

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NOTE: Date & initial all entries

Picklist Print

March-16-12 1:58:06 PM

Page 2

Work Order ID: 81677

81677

Parent Item: D4108-049

D4108-049

Parent Item Name: Litter Door Fitting Assembly

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

MS21043-5

Purchased

No

110

Each

499.0000

1

6

MS21043-5

Nut

**

FF 12-11-01

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

54

112314

54

ST301

425

116548

100

118159

100

119307

25

119537

200

6

D4108-9

Manufactured

No

110

Each

1.0000

1

6

D4108-9

Fitting, Litter Door

**

FF 12-11-01

Location

Loc Qty

Loc Code

st128

B84009

1

64805

1

6

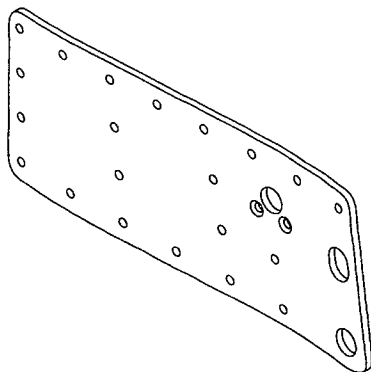
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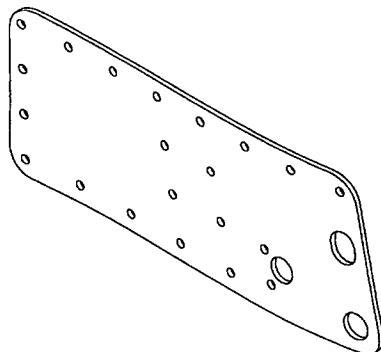
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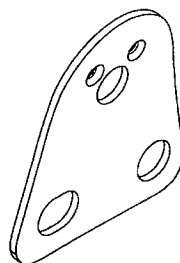
NOTE: Date & initial all entries



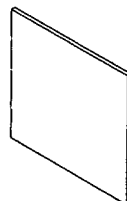
D4108-1 LEFT PASS DOOR DOUBLER



D4108-3 RIGHT PASS DOOR DOUBLER



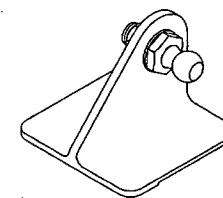
D4108-5 SMALL RIGHT DOOR DOUBLER



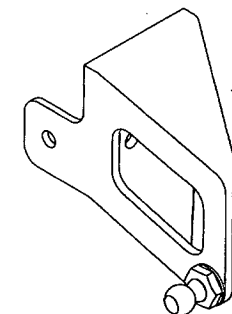
D4108-11 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81677 MCT

12/03/16



D4108-047 SILL BRACKET ASSEMBLY



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,6)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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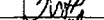
W/O:		WORK ORDER CHANGES					
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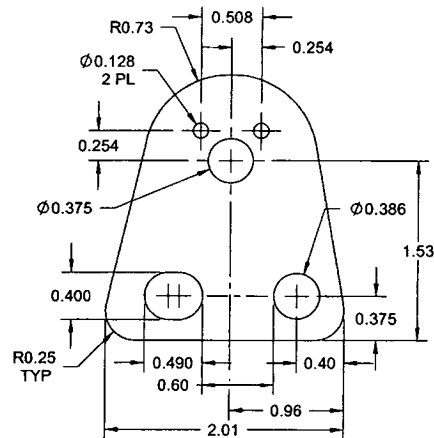
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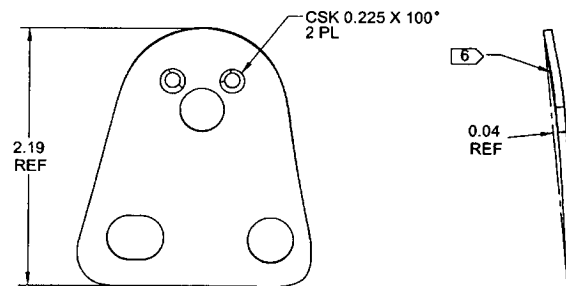
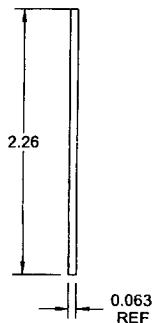
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NOTE: Date & initial all entries

81677



D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER



D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)

NOTES:

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

RELEASED
2010-11-30

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 4 OF 7
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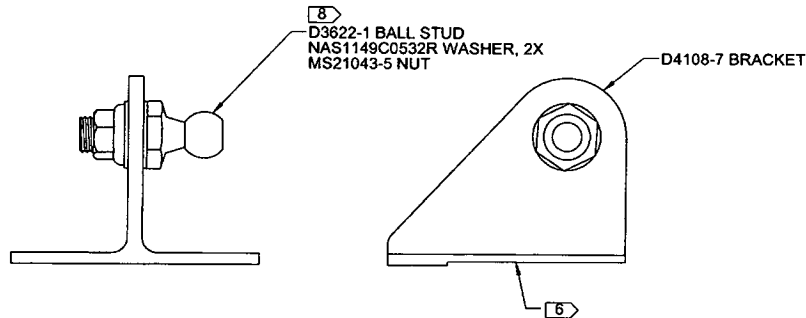
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

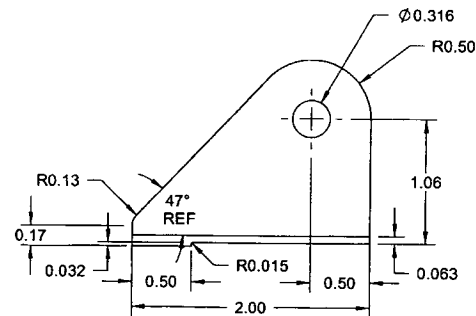
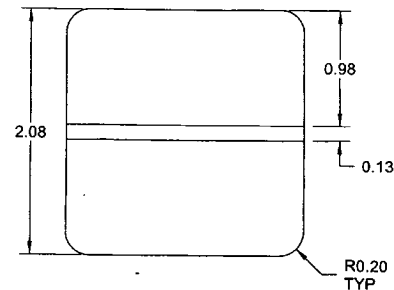
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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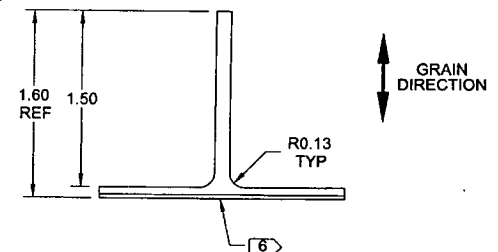
Qty	Part Number	Description
1	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-047 SILL BRACKET ASSEMBLY



D4108-7 BRACKET



- NOTES:**
- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -047: 0.10 lbs
 - 8) TORQUE TO 5-10 INCH POUND.

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2010-11-03
AM

g1677

W/O:		WORK ORDER CHANGES					
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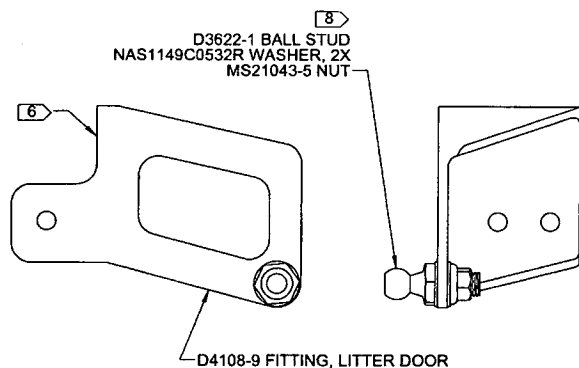
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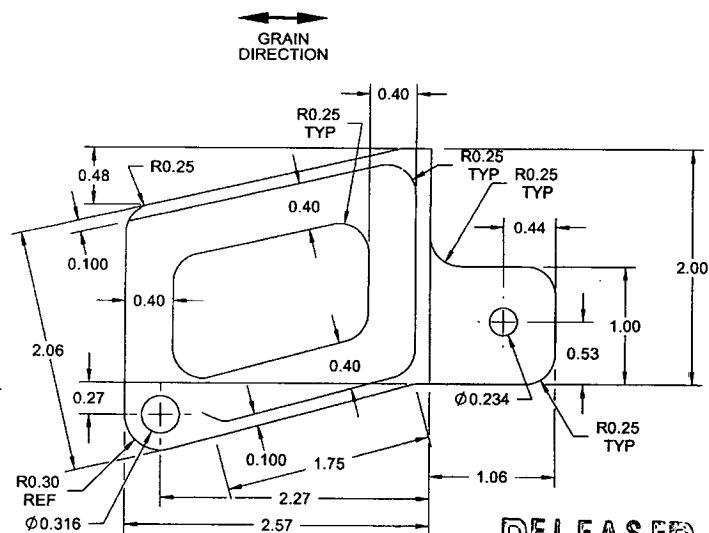
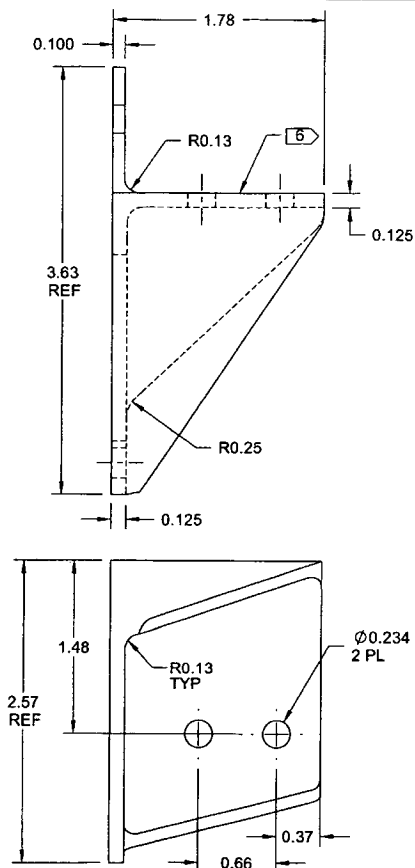
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NOTE: Date & initial all entries

Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

- NOTES:
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -049: 0.19 lbs
 - 8) TORQUE TO 15 INCH POUND.

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2010-11-30
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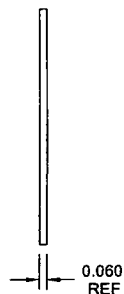
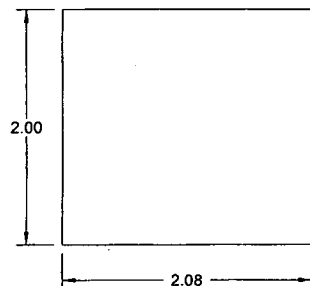
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NOTE: Date & initial all entries

81677



D4108-11 TEMPLATE

RELEASED
2010-11-30

NOTES:

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 7	
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